

Work Order ID 124940

124940

Page 1

Monday, September 29, 2014 9:19:26 AM

Item ID: 41228-700-011-001

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Grounding Bracket Assembly

Start Date: 9/29/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/10/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: 

Date: 14-9-29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
41228-700-011	IR

110

0.00

110

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK

4 0 J.C.L. 14/11/04 DAS 20 9-89

120

Manufacture as per dwg

0.00

120

Mill Conv

Memo

0.00

Conventional Milling Machine

4 0 J.C.L. 14/11/06 14-11-06 DAS 20 9-89

130

QC2- Inspect parts off machine FAI/FAIB

0.00

130

QC

Memo

0.00

Quality Control

4 0 J.C.L. 14/11/06 14-11-06 DAS 20 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

DQA: _____ Date: _____

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Equip/Tooling									
Handling/Pre									
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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 124940

Monday, September 29, 2014 9:19:26 AM

124940

Page 4

Item ID: 41228-700-011-001

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Grounding Bracket Assembly

Start Date: 9/29/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/10/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC5- Inspect part completeness to step on W/O	0.00				(4)			DAS 38 9-89
200									
QC	Memo	0.00							
Quality Control									NOV 28 2014
210	Identify as per dwg & Stock Location: PAF CA1	0.00				(4)			DAS 46 9-89
210									
Packaging	Memo	0.00							
Packaging									DEC 02 2014
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									MCS MAY 04 2015

MCS APR 30 2015

DQA: _____ Date: _____



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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Monday, September 29, 2014 9:19:30 AM

Work Order ID: 124940

124940

Parent Item: 41228-700-011-001

41228-700-011-001

Parent Item Name: Grounding Bracket Assembly

Start Date: 9/29/14

Required Date: 10/10/14

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3A1.0X1.5X12 5		Purchased	No				f	72.0000		1			

M2024T3A1 0X1 5X125

Angle 2024T3511 1.0x1.50x .125w

J.C.-L. 14/11/04

Location

Loc Qty

Loc Code

MAT028

72

130 691
121697

72

Each

10.0000

0.41'

4 0.44'

MS90298-2

Purchased

No

MS90298-2

RECEPTACLE

(Not pull off the system)

Location

Loc Qty

Loc Code

CA

10

M129682

10,

4

KC

15-4-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
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Training									
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Unapproved									

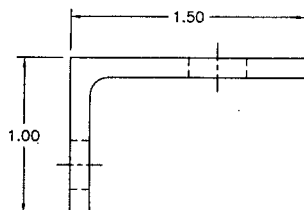
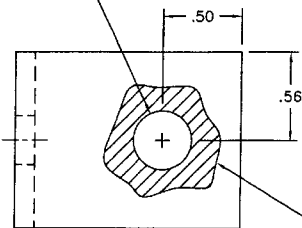
FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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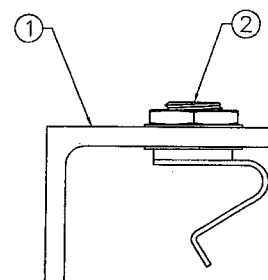
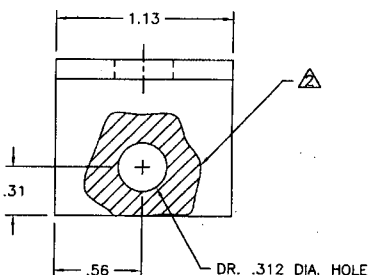
DART AEROSPACE LTD		Work Order:	124940
Description: Bracket		Part Number:	41228-700-011-00
Inspection Dwg:	Rev: IR	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

DR. .375 DIA. HOLE



-003 BRACKET



-001 ASSY

△ WIRE BRUSH HOLES, BOTH SIDES TO BARE METAL
IN ACCORDANCE WITH MIL-B-5087.

△ FINISH IN ACCORDANCE WITH ERA PROCESS SPECIFICATION
NO. 4003, 4004 & 4006.

NOTES:

114-9-29
124940

1	2	MS90298-2	RECEPTACLE						
1	1	-003	BRACKET	.125 x 1.0 x 1.5 L x 1.13 LG	2024-T3511 ALUM.	QQ-A-200/3			
		-001	ASSY						
		-001 FND NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL. SPEC	ZONE	
NO. REQ'D PER ASSY				LIST OF MATERIAL					
PROPRIETARY RIGHTS NOTICE THESE DATA ARE PROPRIETARY TO ERA AVIATION, INC. DISCLOSURE, REPRO- DUCTION, OR USE OF THESE DATA FOR ANY PURPOSE, IS FOR- BIDDEN WITHOUT WRITTEN AUTHORIZATION FROM ERA AVIATION, INC. THE FOLLOWING DOES NOT APPLY TO VENDOR PARTS.				UNLESS OTHERWISE SPECIFIED X.4.1 XX.4.03 XXX.4.010 ANGLES ±.1/2°		DRAFTSMAN D. NELSON 9/22/99 CHECK STRESS PROJ. ENGR.		TITLE GROUNDING BRACKET ASSY DWG. NO. C SCALE 2:1	
-001	2	41228-700-001		HEAT TREAT FINISH		Era Aviation, Inc.		DWG. NO. 41228-700-011	REV. IR
DASH NO. REQ'D PER ASSY				NEXT ASSEMBLY		MIL			

Jean-Luc Menard

From: Roberto Fuentes
Sent: November-05-14 9:47 AM
To: Jean-Luc Menard
Cc: Kevin Cadieux; David Duval; Mario Poulin
Subject: RE: 41228-700-011 brackets for 412 AUX TANK

It is acceptable.

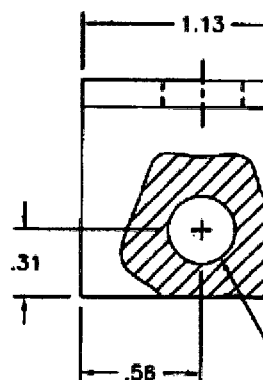
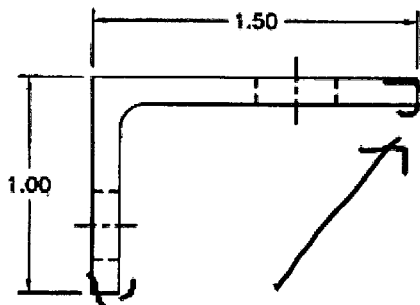
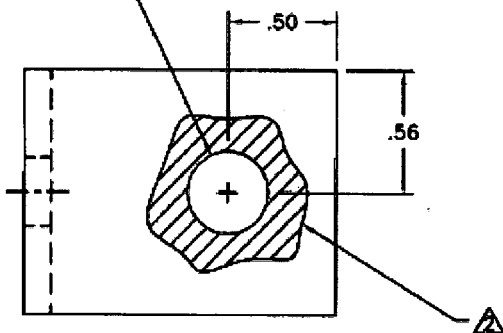
Roberto

From: Jean-Luc Menard
Sent: November-05-14 7:33 AM
To: Roberto Fuentes
Cc: Kevin Cadieux; David Duval; Mario Poulin
Subject: 41228-700-011 brackets for 412 AUX TANK

Hi Roberto,

We received the raw extrusion for these brackets and the material (Angle) came in with a rad on the outer edges, is this acceptable?

DR. .375 DIA. HOLE



.062 RAD

-003 BRACKET